



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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PRELIMINARY ISSUE

D5733-041

Job Sheet 197861



Part No: D5733-041

Job Qty: 4 pcs

Part Name: Bearpaw Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5733 REV:A2 IPP REV:A 19.07.15 NEW ISSUE DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE JUL 18 2019

RELEASED 55 DATE OCT 1 2019

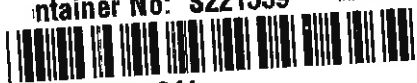
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Large Fab - Welded Assy-1	4 pcs	8/20/19		0.00	4.00	Large Fab - 1		mf
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
135	Automated Welding - B4B	4 pcs	8/20/19		0.00	0.67	Automated Welding - 1 - B4B		mf
140	QC 9	4 pcs	8/20/19		0.00	0.00	QC 9 - 10		n
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
150	QC 5	4	8/20/19		0.00	0.00	QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S221559



Part No: D5733-041

Job No: 197861

Serial No/Batch: S221559

Revision: A

Inspector:

Date:

Instructions:

Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON K6A
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/10/19

Plex 7/18/19 7:24 AM Dart.lajeunesse.marie

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	12
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	4 pcs	8/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	DAS
					Packaging 3 - 33 - B4B	21
					Packaging 3 - 34 - B4B	9-89
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
170	QC 21 - SA	4 pcs	8/20/19	0.00 0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-89
					QC 21 - SA - 53	

See Marcel

DAS
55
9-89

OCT 10 2019

OCT 10 2019

OCT 10 2019

Part Op 130 - WELD CUPS AS PER DWG
 Descriptions: 135 - (Automated welding) WELD HARDFACING AS PER DWG USING DT10453 8259 BATCH: M139018

- 140 - QC9- Inspect visual per QSI004- Fusion Welds
 150 - QC5- Inspect part completeness to step on W/O
 160 - Identify as per dwg & Stock Location: _____
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation
D3009-3	Cup	32 pcs (8 ea)	130-Large Fab - Welded Assy-1
D5703-1	Cup	16 pcs (4 ea)	130-Large Fab - Welded Assy-1
D5733-1	Wearplate	4 pcs (1 ea)	130-Large Fab - Welded Assy-1

Container

5220946
 5206510
 5218425

7/18/2019

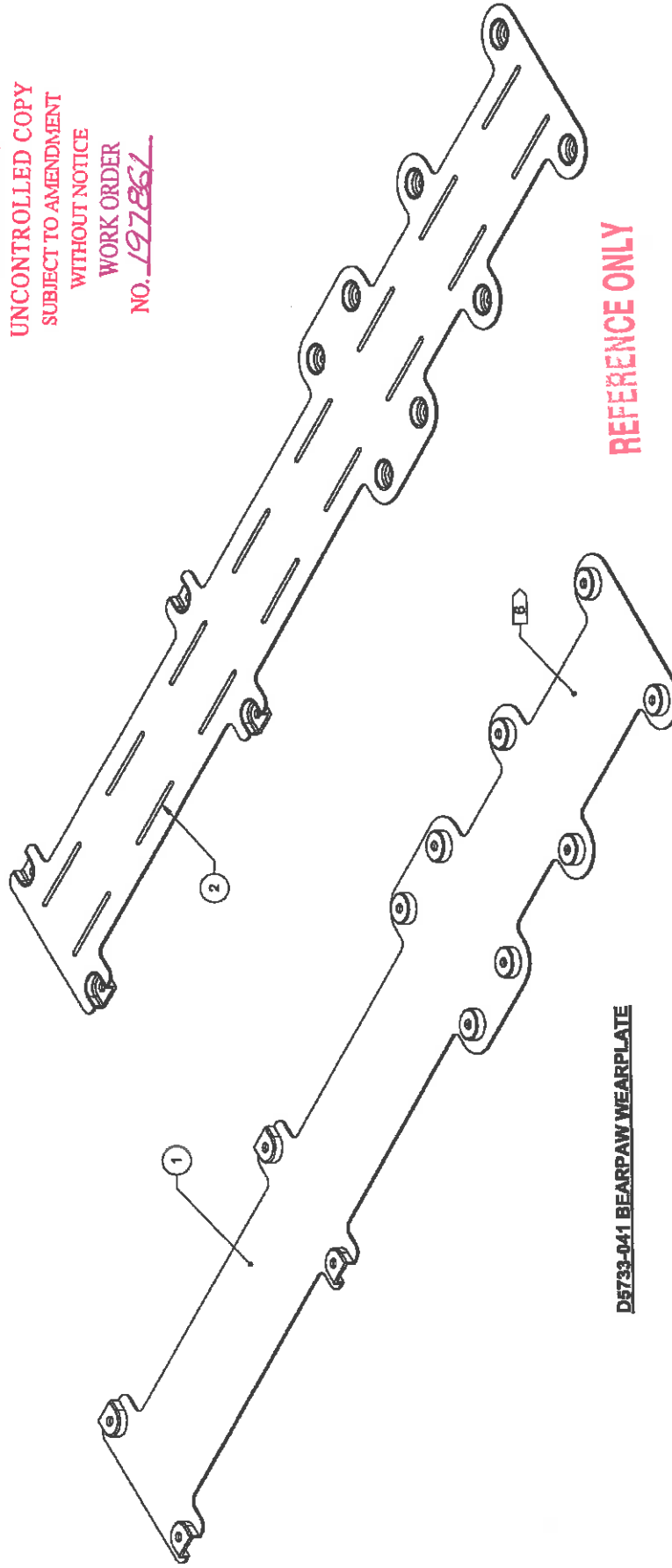
[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
130-Large Fab - Welded Assy-1	D3009-3	32	68	0
	D5703-1	16	0	0
	D5733-1	4	0	0
Part Specifications				
Specifications could not be found.				

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ITEM	QTY	P/N	DESCRIPTION
	X	D5733-041	BEARPAW WEARPLATE
1	1	D5733-043	WEARPLATE WELDMENT
2	AR	8259 1 2059B	HARD SURFACING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197861



REFERENCE ONLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 & 1
 - 7) WEIGHT: 3.02 lbs
 - 8) WELDING: PER QSI 004
 - 9) BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

REV.		NEW ISSUE		DATE	
DESIGN	RF	RF	BY	DATE	
DRAWN	RF				
CHECKED	PM				
MFG. APPR.	RQ				
APPROVED	DSW				
DATE	19.05.22				

APPROVED

DART AEROSPACE USA, INC.
HILLSBORO, OR

DRAWING NO. D5733
REV. A
SHEET 1 OF 4

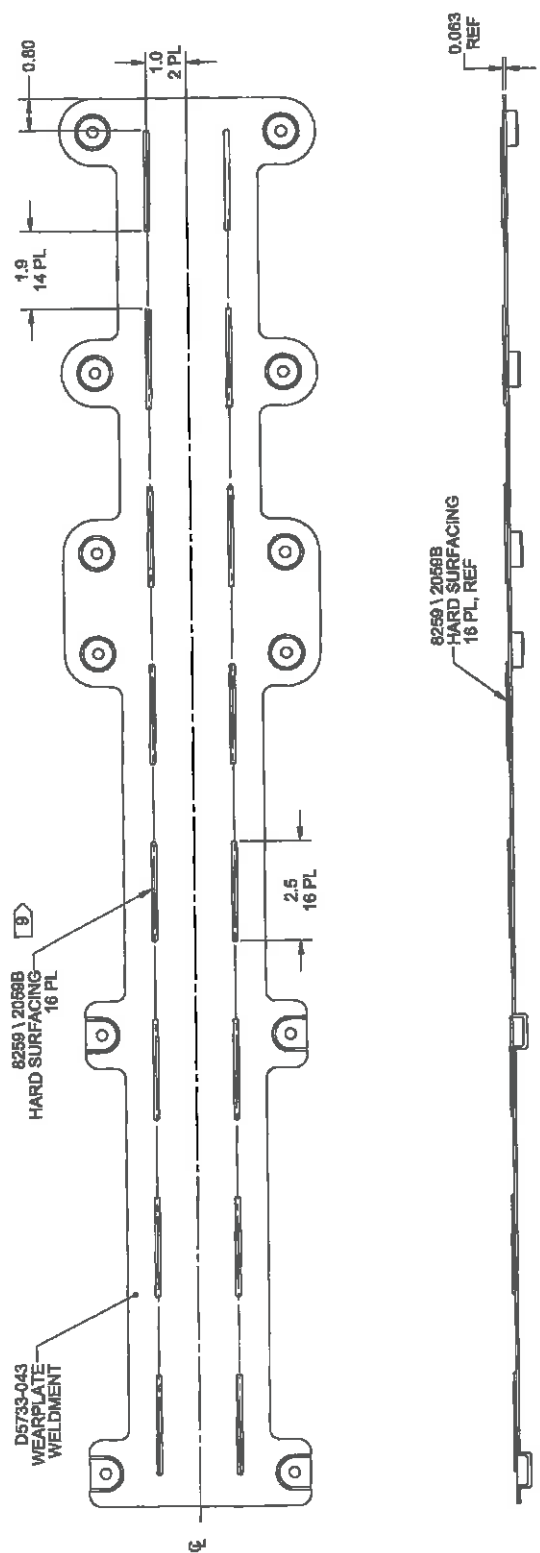
TITLE
BEARPAW WEARPLATE

SCALE
NTS

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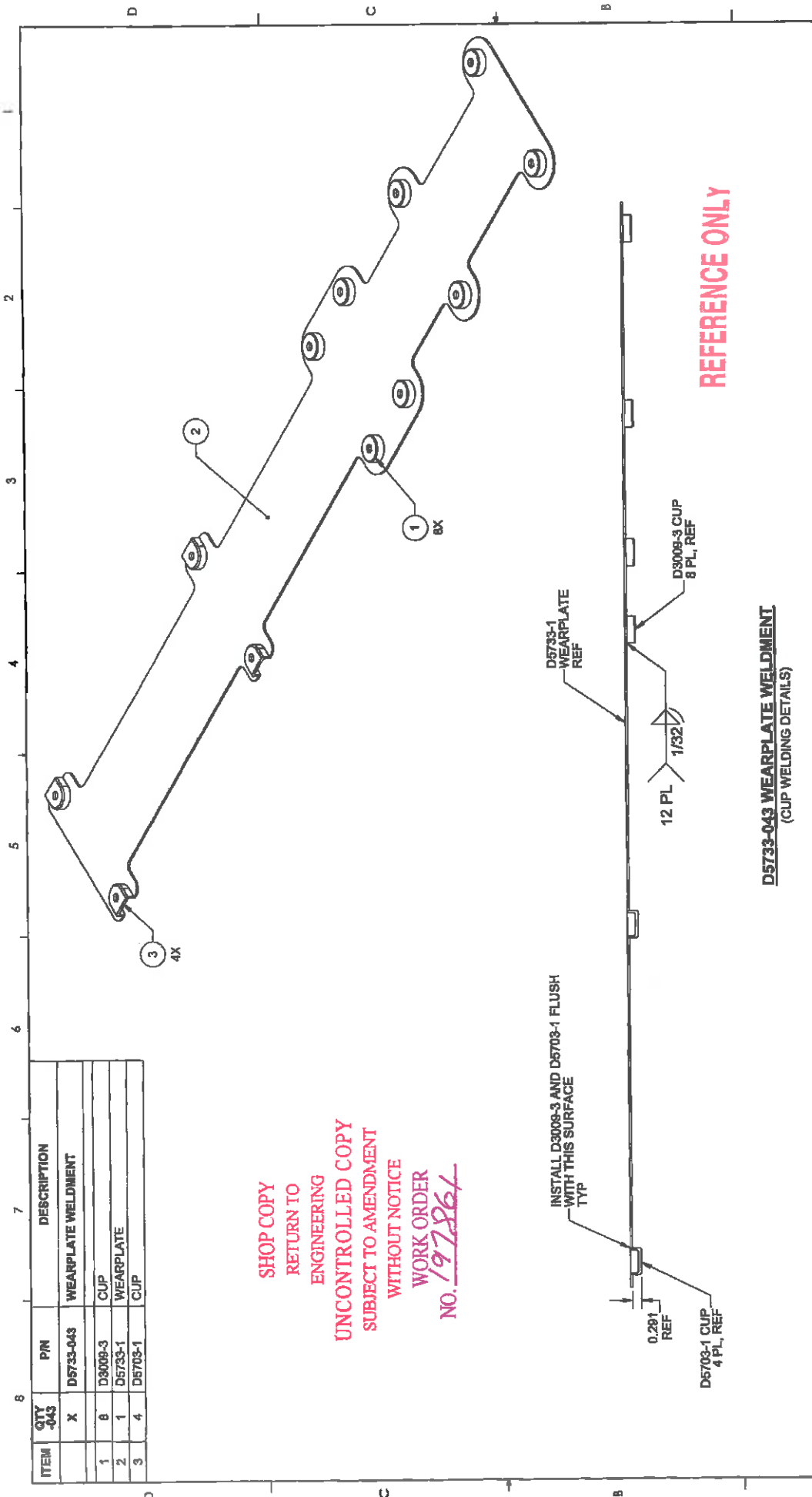
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D5733-041 BEARPAW WEARPLATE
(HARD SURFACING DETAILS)

REFERENCE ONLY

DESIGN	RF	RF	DART AEROSPACE USA, INC.
DRAWN	RF	RF	HILLSBORO, OR
CHECKED	PM	PM	DRAWING NO. D5733
MFG. APPR.	RQ	RQ	REV. A SHEET 2 OF 4
APPROVED	DSW	DSW	TITLE BEARPAW WEARPLATE
DE APPR.	DS	DS	SCALE NTS
DATE	19.05.22	19.05.22	DATE

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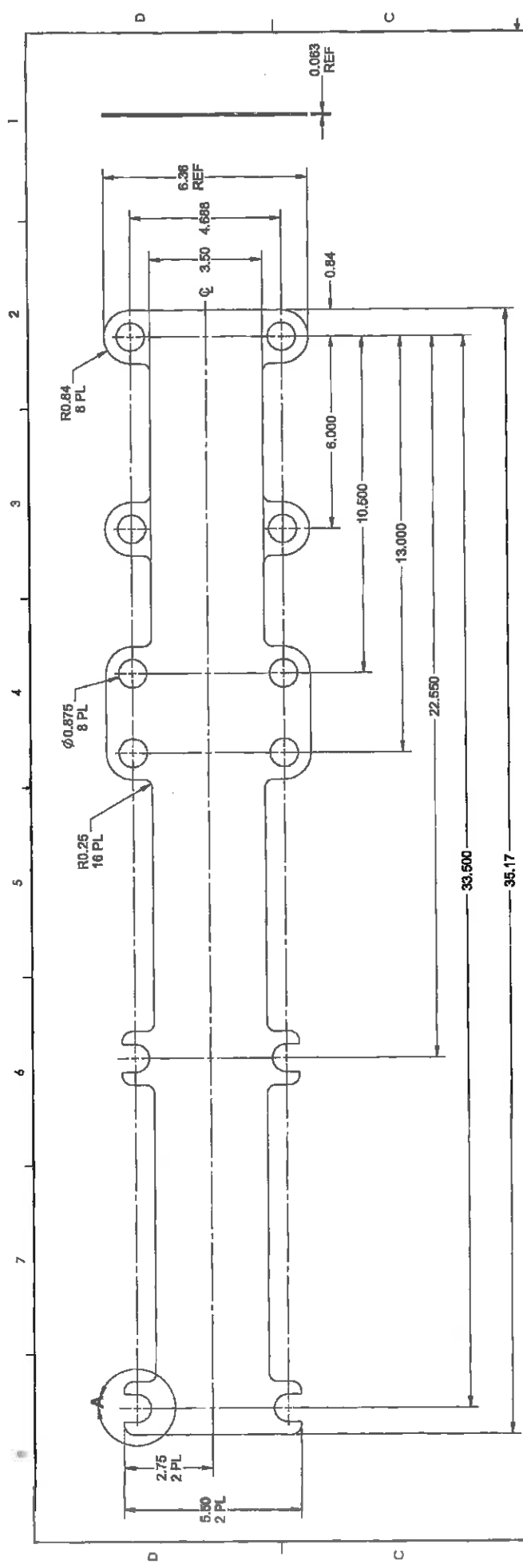
ITEM	QTY	P/N	DESCRIPTION
	X	D5733-043	WEARPLATE WELDMENT
1	8	D3008-3	CUP
2	1	D5733-1	WEARPLATE
3	4	D5703-1	CUP

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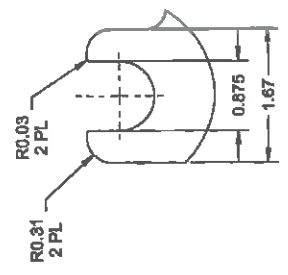
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DRAWN	RF	RF	HELLSBORO, OR
CHECKED	PM	PM	DRAWING NO.
MFG. APPR.	RQ	RQ	D5733
APPROVED	DSW	DSW	REV. A
DE APPR.	DSW	DSW	SHEET 3 OF 4
DATE	19.05.22	DATE	19.05.22
		TITLE	BEARPAW WEARPLATE
		SCALE	NTS

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.86 lbs
 - 8) WELDING: PER QSI 004

D5733-043 WEARPLATE WELDMENT
(CUP WELDING DETAILS)



D5733-1 WEARPLATE



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REFERENCE ONLY
SP
12/14/27

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 0.083 THICK PER MIL-S-5088 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.54 lbs

DETAIL A
(TAB DETAIL)
4 PL
SCALE 2X

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CHECKED		PM	PM	DRAWING NO.	
MFG. APPR.		RQ	RQ	D5733	
APPROVED		DSW	DSW	REV. A	
DE APPR.		DS	DS	SHEET 4 OF 4	
DATE		19.05.22		TITLE	
				BEARPAW WEARPLATE	
				SCALE	
				NTS	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐
Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

MRB (QSI042)

Date: _____ Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐
Bending ☐ ☐ ☐
Crushing ☐ ☐ ☐
Cracks ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐
Mislabeled ☐ ☐ ☐
Other/Details: _____

Contamination ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐
BOM/Route ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐
Drill Holes ☐ ☐ ☐
Fit/Function ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐
Folio/Program ☐ ☐ ☐
Grain Direction ☐ ☐ ☐
Weld ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐
Positioned Wrong ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐
Drawing ☐ ☐ ☐
Finish ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐
Misread ☐ ☐ ☐